

Work Order ID 148198

Monday, June 27, 2016 11:41:23 AM

148198

Page 1

Item ID: D412-698-031

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Door Roller LH Composite Door

Start Date: 7/22/2016 Start Qty: 2.00

**2* SK*

Cust Item ID:

Required Date: 8/2/2016 Req'd Qty: 2.00

Customer:

Reference:

DAS

Approvals:

Process Plan:

13
9-89

Date: JUN 27 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr							DAS 21 9-89	<i>160728</i>
IIN D412-698	Rev <i>EF</i>	<i>PC</i>							

100 Document Control 0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-698-031

CHG001

2 **DAS**
28
9-89 **JUL 28 2016**

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

Q R **DAS**
27
9-89 **JUL 26 2016**

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo

0.00

Quality Control

2 **DAS**
28
9-89 **JUL 28 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐		Part Moved ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐		Drawing ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Finish ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____							
Misidentified ☐		Past Due ☐									

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Page 2

Item ID: D412-698-031

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Door Roller LH Composite Door

Start Date: 7/22/2016 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 8/2/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				2	DAS 28	DAS 27	AUG 03 2016
130							9-89	9-89	
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-031 Locaiton : FG034								
140	QC21- Final Inspection - Work Order Release	0.00					DAS 21		AUG 03 2016
140							9-89		
QC	Memo	0.00							
Quality Control									

Sta 8/3/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																				
OTHER :																									

Monday, June 27, 2016 11:41:22 AM

148198

D412-698-031

Start Date: 7/22/2016

Required Date: 8/2/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-143		Manufactured	No			120	Each	0.0000	1	2			DAS 27 9-89
D3121-143 Bracket Assembly DAS 28 9-89 2 X B148 060 PC													
D3137-043		Manufactured	No			120	Each	1.0000	1	2			DAS 27 9-89
D3137-043 Bracket Assembly DAS 28 9-89 1 X B148 252 PC													
D3183-043		Manufactured	No			120	Each	1.0000	1	2			DAS 28 9-89
D3183-043 Bracket Assembly DAS 28 9-89 1 X B148 266 PC													
D3202-3		Manufactured	No			120	Each	0.0000	1	2			DAS 27 9-89
D3202-3 Cover DAS 28 9-89 148300													
D3674-041		Manufactured	No			120	Each	51.0000	3	6			DAS 27 9-89
D3674-041 Roller Bracket Assembly DAS 28 9-89 5 X B143 720 PC													
D3674-043		Manufactured	No			120	Each	51.0000	3	6			DAS 27 9-89
D3674-043 Roller Bracket Assembly DAS 28 9-89 5 X B143 720 PC													

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____	

Picklist Print

Monday, June 27, 2016 11:41:22 AM

Work Order ID: 148198

148198

Parent Item: D412-698-031

D412-698-031

Parent Item Name: Cabin Door Roller LH Composite Door

Start Date: 7/22/2016

Required Date: 8/2/2016

Start Qty: 2.00

Required Qty: 2.00

D3675-1

Manufactured No

120

Each

11.0000

9

18

D3675-1

Sliding Door Bracket

**

7X.B148408

PC

Location

Loc Qty

Loc Code

ST050

11

142135

11

DAS
28
9-89
9-89

DAS
28
9-89
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
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Root Cause				FAULT CATEGORY																																																																																																																											
Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	No Re-verification	☐	Operator	☐	Offset/Setup	☐	Supplier	☐	Training	☐	Use for Testing	☐	Poor Information	☐	Rushing	☐	Product Improvement	☐	Process Improvement	☐	Manufacturing Process	☐	Past Due	☐	Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	☐	Temperature/Cure	☐	Set-up	☐	BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐	Power Loss/Surge	☐	Folio/Program	☐	Grain	☐	Weld	☐	Wrong Stock Pulled	☐	Out of Sequence	☐	Off-set	☐	Mislabeled	☐	Fit/Function	☐	Misaligned/off center	☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence	☐
OTHER :																																																																																																																															

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Qty -037	Qty -038	Part Number	Description
X								D412-698-019	BEARING OVERHAUL KIT
	X							D412-698-021	REPLACEMENT SHIM KIT
		X						D412-698-031	CABIN DOOR ROLLER KIT, LH
			X					D412-698-032	CABIN DOOR ROLLER KIT, RH
				X				D412-698-033	REPLACEMENT DOOR TRACK KIT
					X			D412-698-035	DOOR HANDLE KIT
						X		D412-698-037	BRACKET KIT, LH (COMPOSITE DOORS)
							X	D412-698-038	BRACKET KIT, RH (COMPOSITE DOORS)
7								D3121-21	BOLT
5								D3121-241	BEARING ASSEMBLY
1								D3137-3	GUIDE
1								D3137-5	WASHER
2								D3183-045	BEARING ASSEMBLY
	3							D3238-1	SHIM
	1							D3238-3	SHIM
	2							D3238-5	SHIM
	6							D3238-11	SHIM
	2							D3238-13	SHIM
	4							D3238-15	SHIM
		1						D3121-143	BRACKET ASSEMBLY
			1					D3121-144	BRACKET ASSEMBLY
		1	1	1				D3202-3	COVER
		3	3					D3674-041	BRACKET ASSEMBLY
		1						D3674-043	ROLLER BRACKET ASSEMBLY
			1					D3674-044	ROLLER BRACKET ASSEMBLY
		1	1					D3674-045	ROLLER BRACKET ASSEMBLY
		9	9	9				D3675-1	BRACKET
						1		D3675-5	FORWARD BRACKET, LH
							1	D3675-6	FORWARD BRACKET, LH
					2			D3779-041	HANDLE ASSEMBLY
					2			D3779-3	PLATE
					2			D3779-043	HANDLE ASSEMBLY
					12			AN525-832R8	SCREW
					12			NAS1149D0332J	WASHER (AN960JD10L)
					12			MS21042L3	NUT
					12			MS24694-S51	SCREW
1								MS24694-S101	SCREW

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Revision: F

Date: 16.05.11